

**Work Order ID 72748**

Friday, August 12, 2011 7:04:55 AM



Page 1

Item ID: D4292-1

Accept



Setup Start



Revision ID:

Item Name: Fitting

Stop



Start Date: 8/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

*mf*

Date: 11-08-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4292

C

200

0.00



Mill Conv

Conventional Milling Machine

Memo

PULL FROM STOCK D4292-1  
ENLARGE MOUNTING HOLE SIZE  
FROM .0266" TO 0.323".

DEBURR AND TOUCH UP WITH ALODIN 1200/1200 PER MIL-C-5541

0.00

*11/08/12**2*

210

0.00



HandFinish

Hand Finishing

Memo

0.00

*11/08/12**2*

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Page 2

Item ID: D4292-1

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Setup Start



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Start Date: 8/12/2011 Start Qty: 2.00



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Required Date: 8/12/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

**ENGINEERING  
APPROVAL**

11/08/12

2

Quality Control

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

5/10/12

2

Quality Control

240

Identify as per dwg &amp; Stock Location:

0.00



Packaging

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

basket

### 3.0 INSTALLATION PROCEDURE

#### 3.1 Initial Installation

- 3.1.1 To facilitate the installation of the D407-797-011/-012/-013/-014 *Quick Release Heli-Utility-Basket™*, remove the steps that are attached to the landing gear on the side of the aircraft that the basket is being installed.
- 3.1.2 Raise the helicopter using a hoist and remove landing gear per the Aircraft Maintenance Manual.
- 3.1.3 Remove the existing Fwd/Aft Support Fittings per the Aircraft Maintenance Manual or relevant STC. Retain the existing hardware.
- 3.1.4 Enlarge the 2 mounting holes on the D4292-1 Forward Support Fitting from  $\varnothing 0.266"$  to  $\varnothing 0.323"$ . Deburr and touch up with Alodine 1200/1201 per MIL-C-5541.
- 3.1.5 Install the D4292-1 Forward Support Fitting (2 PL) and D4294-1 Aft Support Fitting (2 PL) using the existing hardware. Torque the bolts per Table 1.

**Table 1 – Fastener Torque**

Size	Torque	
8-32	12-15 in-lbs	1.4-1.7 N-m
3/16"	20-25 in-lbs	2.3-2.8 N-m
1/4"	50-70 in-lbs	5.6-7.9 N-m
5/16"	100-140 in-lbs	11.3-15.8 N-m
3/8"	160-190 in-lbs	18.1-21.5 N-m
MS27151-19	29-60 in-lbs	3.2-6.7 N-m

- 3.1.6 Locate the landing gear under the aircraft and carefully lower the aircraft to seat the four mounting points of the D4292-1, D4294-1 Support Fittings onto the supports of the crosstubes.
- 3.1.7 Re-install the existing Fwd Strap Assemblies (Bell Part # 206-052-105-035), Aft Support Assemblies (Bell Part # 400-052-015-101) using existing hardware. Tighten the bolts to a snug fit.
- 3.1.8 Lower the aircraft onto the ground and remove the hoisting equipment. Verify that the aircraft is set correctly onto the crosstubes. Torque bolts on Fwd Strap, Aft Support Assemblies per Table 1.
- 3.1.9 Measure the distance between Fwd/Aft Supports (Dim A) and subtract the distance between attachment faces on the basket (Dim B). Install D4314-X Shims on Fwd/Aft Supports as shown in Figure 2 so that  $\text{Dim A} = \text{Dim B} + \text{Shim Thickness}$ .
- 3.1.10 Install the D4271-011 Fwd Beam Assembly using AN6-17A bolts to the D4292-1 Fwd Support Fitting (2 PL) as shown in Figure 1. Torque the bolts per Table 1. Install MS27151-19 Safety Nut as shown in Figure 1 and torque per Table 1.
- 3.1.11 Install the D4271-013 Aft Beam Assembly using AN6-20A bolts to the D4294-1 Aft Support Fitting (2 PL) as shown in Figure 1. Torque the bolts per Table 1. Install MS27151-19 Safety Nut as shown in Figure 1 and torque per Table 1.
- 3.1.12 Ensure D4271-011/-013 Beam Assemblies are flush with D4292-1, D4294-1 Support Fittings using D4314-X Shim (as applicable). It is also acceptable to make Shims of required thickness using Aluminum sheet and finish with Alodine 1200/1201 per MIL-C-5541. Maximum shim thickness to be used at both Fwd/Aft Supports is 0.188" (4.77 mm).
- 3.1.13 Install the D4272-011/-012/-013/-014 Basket Assy per Section 3.2. Confirm that the installation clears the passenger door.
- 3.1.14 Install D4307-X Placard, Max Load as applicable in accordance with Table 2 and at the location shown in Figure 5.

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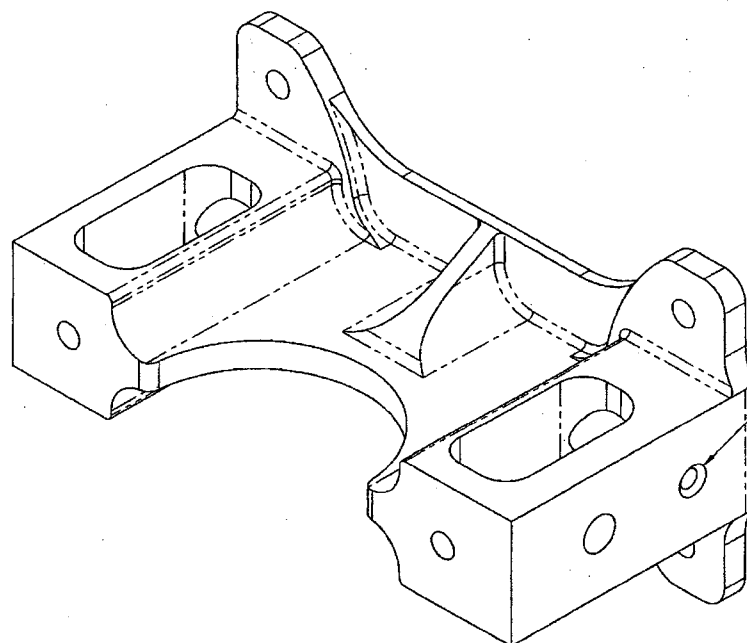
Revision: A  
Date: 10.12.08

# Location/Lot Activity

Friday, August 12, 2011 7:54:01 AM

Page 1 of 1

Criteria :		All Items	All Locations	Lot: 68724	All Transaction Types	All Dates	Report on Locations & Lots				
Transaction Type	Item ID/ Item Name	Warehouse Location ID	Reason	Employee ID Location Code	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date Lot Code	Extended Cost	
Issue	D4292-1 / Fitting	Main Warehouse ST481	70503	FAUT01		2.0000		2.0000			
					6/23/2011	-2.0000	68724	-2.0000		(\$516.38)	
		Main Warehouse ST470	71730	DESJ02		2.0000		2.0000			
					7/20/2011	-2.0000	68724	-2.0000		(\$516.38)	
		Main Warehouse ST470	71730	FAUT01		0.0000		0.0000			
				8/12/2011	2.0000	68724	2.0000		\$516.38		
								-2.0000		(\$516.38)	
Rework	D4292-1 / Fitting	Main Warehouse ST470	72748 ✓	FAUT01		2.0000		2.0000			
					8/12/2011	-2.0000	68724	-2.0000		(\$516.38)	
								-2.0000		(\$516.38)	
								-2.0000		(\$516.38)	
WIP Receipt	D4292-1 / Fitting	Main Warehouse ST481	68724	FAUT01		0.0000		0.0000			
					6/23/2011	2.0000	68724	2.0000		\$516.38	
		Main Warehouse ST470	68724	LAVO01		0.0000		0.0000			
					7/4/2011	2.0000	68724	2.0000		\$516.38	
									4.0000		\$1,032.76



MS21209F1-10 HELICAL COIL, 1X  
REF

GRAIN  
DIRECTION

72748

RELEASED  
2011-02-01

# **D4292-1 FITTING**

## **NOTES:**

- 1) MATERIAL: 7075-T73/-T7351/-T73510/-T73511 BAR  
PER AMS-QQ-A-200/11 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078)  
REF DART SPEC. M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: P/N "D4292-1" AND B/N PER DART QSI 044 6.1
- 7) WEIGHT: 1.02 lbs

C	1.064 WAS 1.235 (C1-2), Ø0.288 WAS Ø0.323 (B3-2), ADD HELICAL COIL (D1-2)	CP	10.12.23
B	0.800 WAS 0.78 (C6-2), 0.825 WAS 0.81 (C4-2)	CP	10.11.30
A	NEW ISSUE	CP	10.11.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.23		

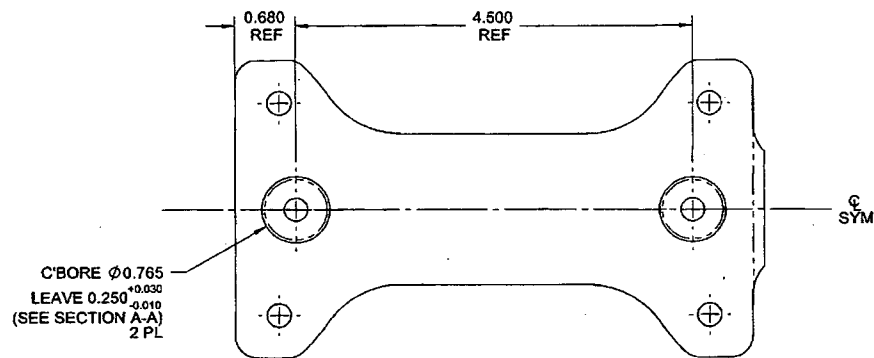
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D4292**  
REV. C  
SHEET 1 OF 3  
TITLE  
**FITTING (206L/407 FWD)**  
SCALE  
NTS

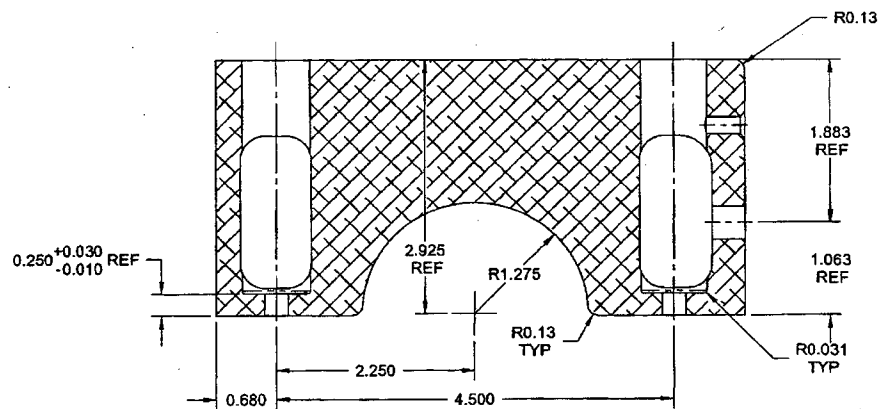
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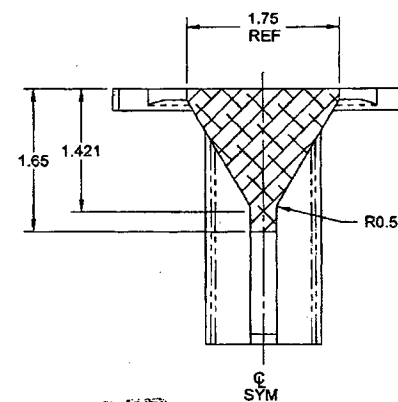
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**VIEW C-C** D3-2



**SECTION A-A** A3-2



**SECTION B-B** C4-2

RELEASED  
2011-02-01

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4292</b>	REV. C
MFG. APPR.		TITLE <b>FITTING (206L/407 FWD)</b>	SHEET 3 OF 3
APPROVED		DATE <b>10.12.23</b>	SCALE <b>NTS</b>
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8 7 6 5 4 3 2 1